

ABSTRACT OF THE DISCLOSURE

A valve assembly for a molding system includes a plurality of sequentially activated valves. The valves suppress the initial surge of each individual fluid material component such that a proper quantity of each component is supplied to the mix head at the beginning of each cycle. Each of the valves includes a respective opening. The feed assembly continues to force fluid material against a first valve until the pressure is above a predetermine value. Once the pressure is above the predetermined value, the controller releases the pressure from an actuator associated with the first valve such that the valve opens. Fluid material can now flow through the valve assembly at a rate suppressed by the first valve. As the feed assembly continues to build toward it operational pressure, each remaining partially closed valve is opened in sequence. The restriction of one valve is thereby replaced by a lesser restriction. By opening the valves at a predetermined pressures the pressure buildup can be readily controlled.

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